

Date: Monday, 1/22/2007 7:43:50 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 BEARPAW INSTALLATION KIT (48")
Job Number	: 30338	Part Number	: D205564011
Estimate Number	: 12283	Drawing Number	: D2521
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 1/22/2007	Drawing Revision	: J
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 2/14/2007
Previous Run	: 28729	Qty:	21 Um: Each
Written By	: <u>[Signature]</u>		
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est F 00-01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

KS 07.01.24

(21)

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 13.6500 sf(s)/Unit Total : 286.6500 sf(s)
 blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6
 Material: Black UHMW 1" M102164 x 17
 (MUHMWB10) M.103315 x 31
 Batch: _____

En 07/01/27

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 (2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

07/02/05 J.L / En

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/02/05 J.L / En

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:43:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 30338

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/02/05 21

6.0

D2182B

Neoprene Cushion-750 bl



Comment: Qty.: 3.7000 f(s)/Unit Total: 77.7000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion B30387 ✓

7.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total: 420.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block B28713 ✓

208 x ✓

151 B30380 ✓

8.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 420.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer B28733 ✓

9.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total: 168.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp B27877 ✓

B30386 29x ✓

88x B25770 52x ✓

10.0

D3544041

CLAMP



Comment: Qty.: 4.0000 Each(s)/Unit Total: 84.0000 Each(s)

CLAMP

Batch: B30386 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:43:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 30338

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 168.0000 Each(s)

Bolt

Batch: M102959 - ✓

12.0

AN415A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total: 420.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20

~~AN4-15A~~

Bolt

M103444 398 X

(12)

M103588

29 - ✓

13.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 420.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416

Washer

M101985

M101988 - ✓

14.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total: 420.0000 Each(s)

Nut

Batch: M19185 - ✓

27/3/8 (11)
27/10/12 (10)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

204/03/08 (21)

SB

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BEUC

204/03/08 (21)

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: HP Date: 07/03/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:43:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 30338

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

9 07/03/09

Job Completion



U 210309

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 30338
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.261	—			
B	0.90	0.96	0.930	—			
C	0.27	0.330	0.306	—			
D	0.470	0.530	0.490	—			
E	21.740	21.760	21.750	—		Tape	
F	0.72	0.780	0.750	—			
G	0.35	0.410	0.374	—			
H	11.490	11.570	11.500	—		Tape	
I	3.41	3.47	3.428	—			
J	11.790	11.810	11.800	—		Tape	
K	9.47	9.53	9.500	—		Tape	
L	7.190	7.210	7.200	—		Tape	
M	6.910	6.970	6.938	—			
N	44.47	44.530	44.500	—		Tape	
O	6.590	6.650	6.628	—			
P	0.940	0.980	0.952	—			
Q	18.97	19.03	19.00	—		Tape	
R	0.350	0.410	0.377	—			
S	0.740	0.780	0.745	—			
T	0.240	0.280	0.254	—			
U	0.370	0.410	0.381	—			
V	0.740	0.780	0.748	—			
W	0.740	0.780	0.750	—			

Measured by: En	Audited by: J.F.	Prototype Approval:	N/A
Date: 07/01/29	Date: 07/01/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

DART

DESIGN #	DRAWN BY C B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30338

RELEASED

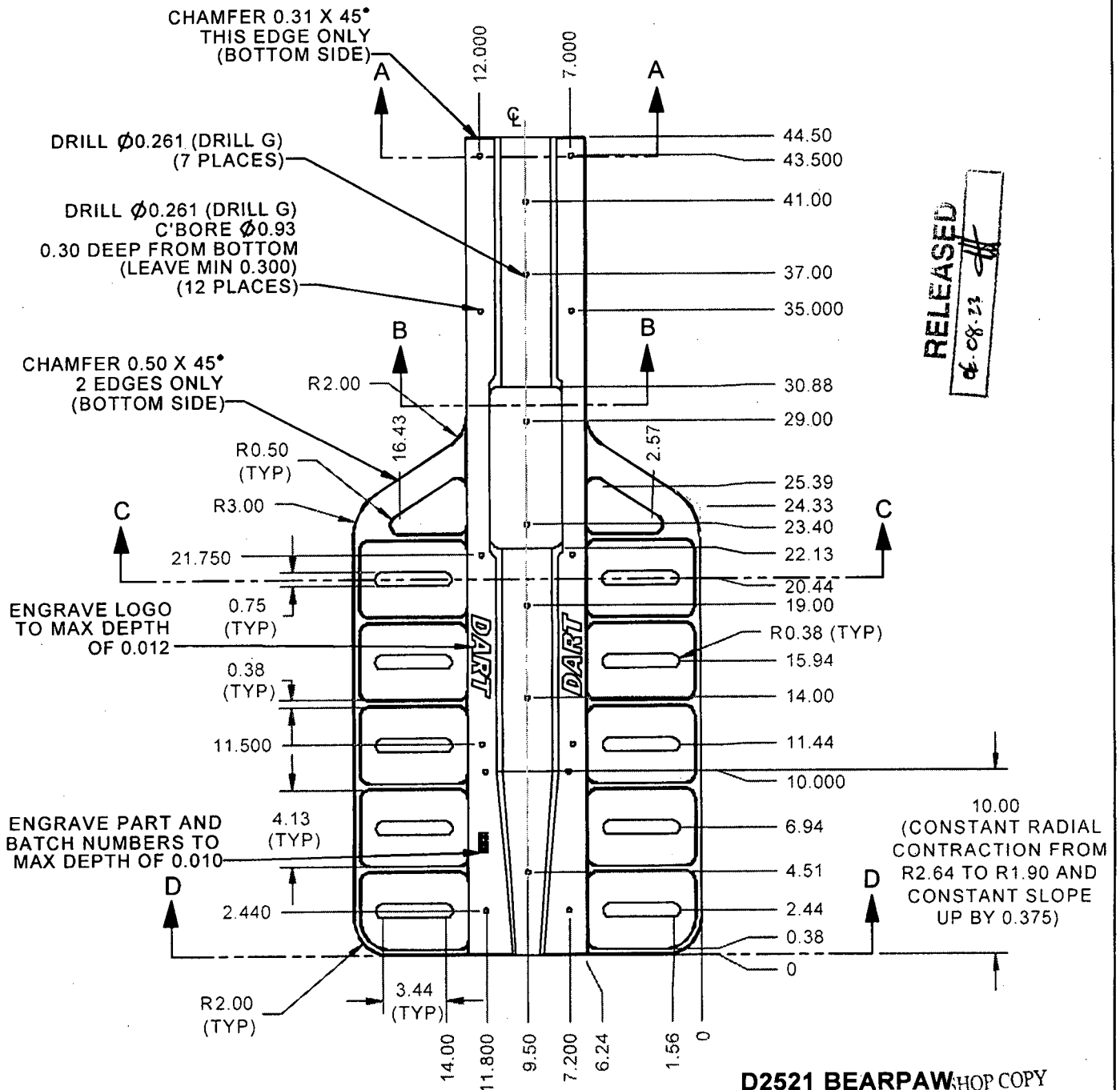
06 08.23 #

COPYRIGHT © 1995 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 2 OF 3 SCALE 1:8	

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT \varnothing

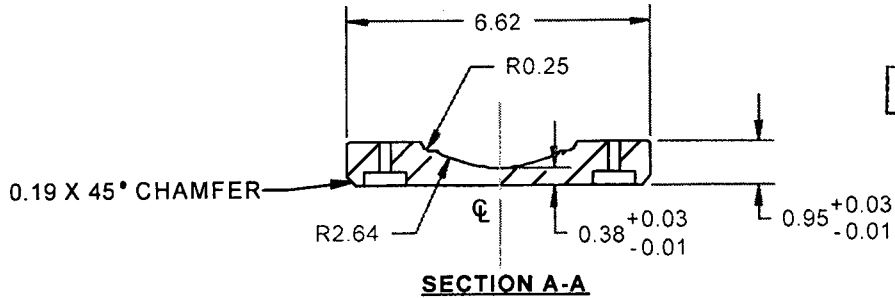
COPYRIGHT © 1995 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

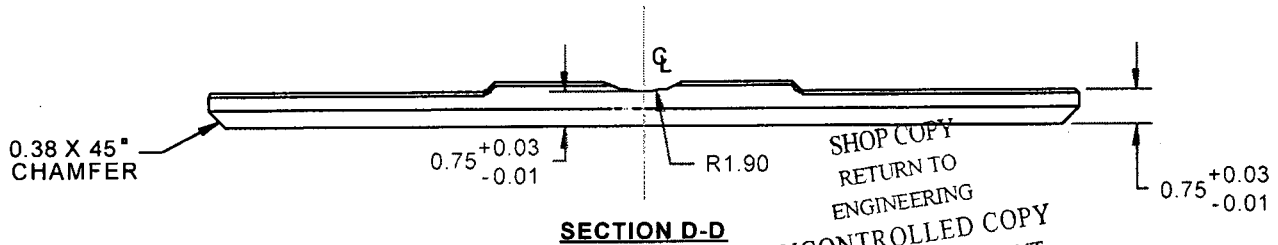
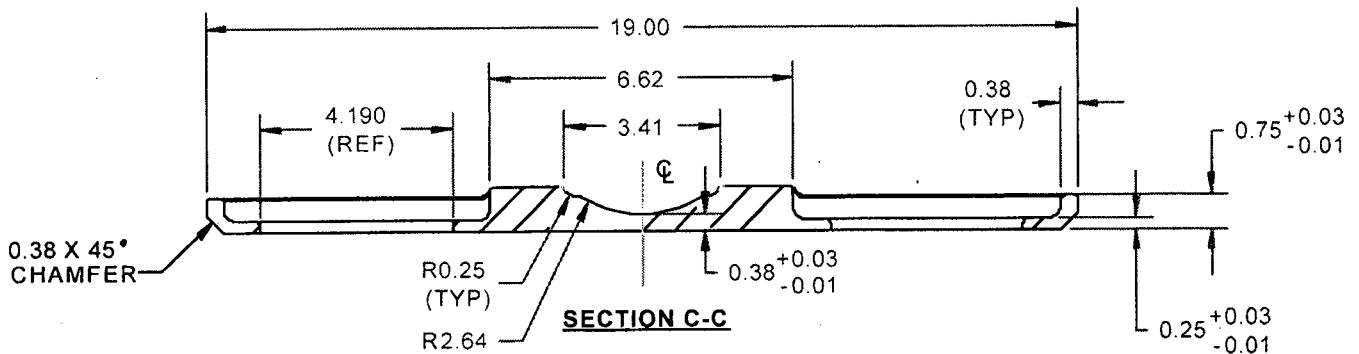
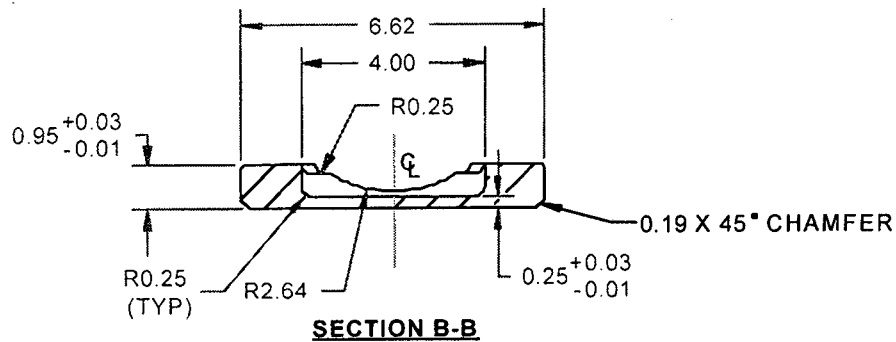
D2521 BEARPAW SHOP COPYRETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30338

DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE 1:4

**RELEASED**

06.08.23 #



SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30338

COPYRIGHT © 1995 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.